

Work Order ID 86149

June-21-12 8:40:23 AM

86149

Page 1

Item ID: D4277-19

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 21/06/2012 Start Qty: 2.00

2 **4X**

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4277

D

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4277
2- Remove marking and deburr

4X CC 14-2-24

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

PC 14.2.25

4X

120

Identify as per dwg & Stock Location: WA004

0.00

120

Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

PC 14.2.25

4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Setup Start ***NS1***

Revision ID:

Item Name: Rib

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 14-02-27

ME
14-2-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:40:28 AM

Page 1

Work Order ID: 86149

86149

Parent Item: D4277-19

D4277-19

Parent Item Name: Rib

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 NEW ISSUE DD verf:EC
11.03.03 AS PER DWG REV.D DD verf:EC

IPP Rev:b

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	741.6551	1.8941	3.987579			

M304TS0 500W 049

Square Tubing

**

CC 14-2-24

Location

MAT034

Loc Qty

741.6550723

0.00001534

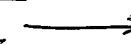
2.059994

182.256363

557.3387

Loc Code

B125062



8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

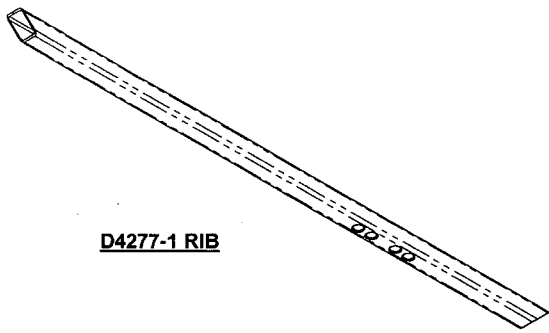
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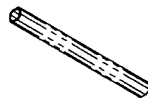
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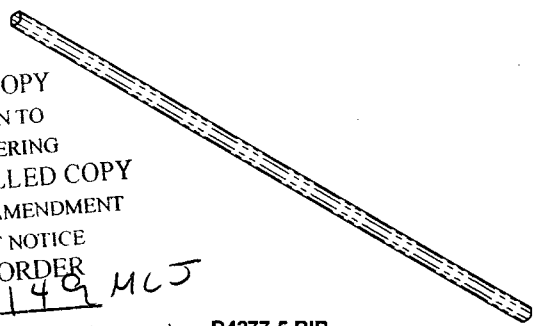
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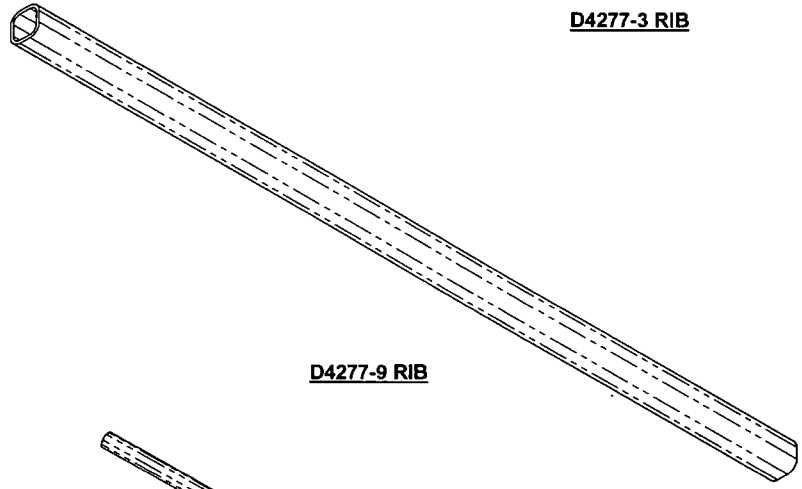
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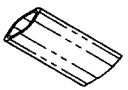
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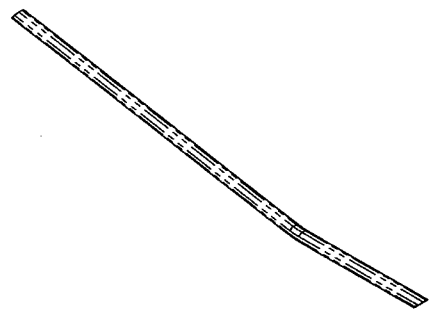
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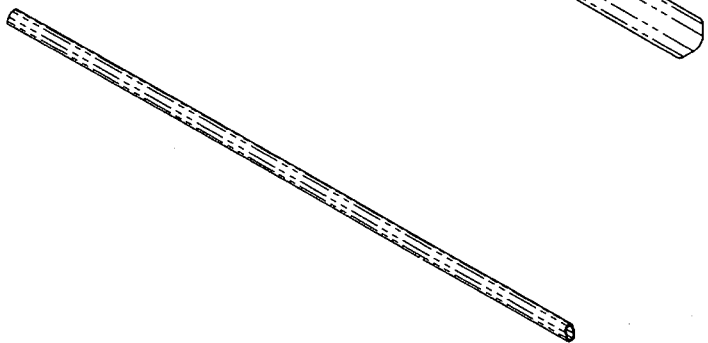
D4277-9 RIB



D4277-7 RIB



D4277-11 RIB



D4277-19 RIB



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86149 MJS

12/06/21

RELEASED
2011-02-24
MP

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	[Signature]	DRAWING NO.	REV. D
MFG. APPR.	[Signature]	D4277	SHEET 1 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	RIBS	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

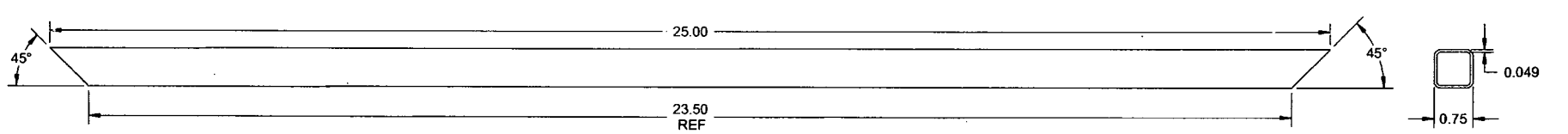
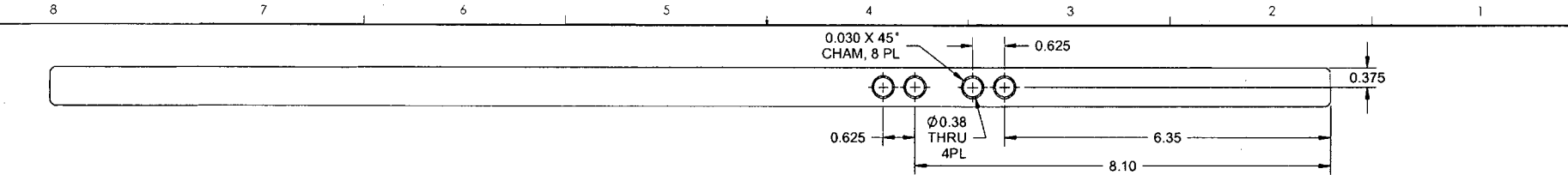
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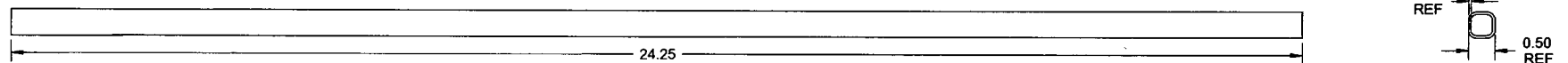
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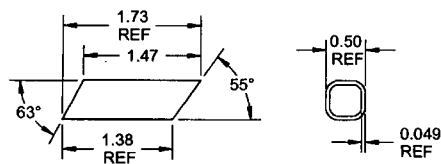
D4277-1 RIB



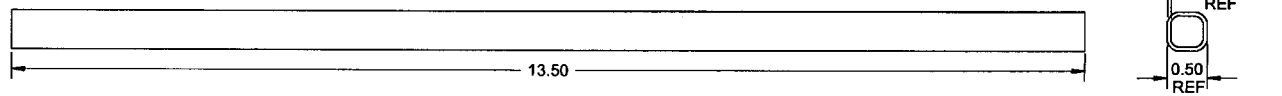
D4277-3 RIB



D4277-5 RIB



D4277-7 RIB



D4277-9 RIB

RELEASED
2011-02-27

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
-3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4277	SHEET 2 OF 3
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DE APPR.		RIBS	NTS
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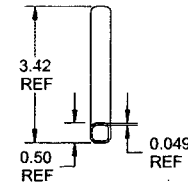
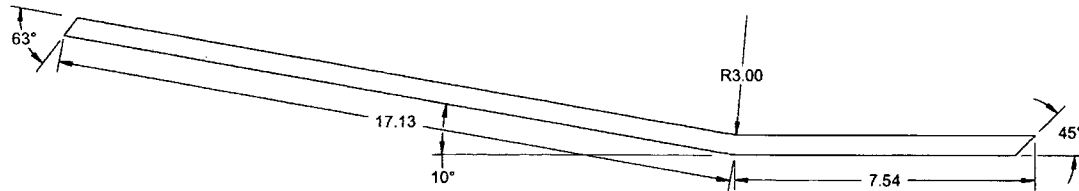
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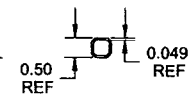
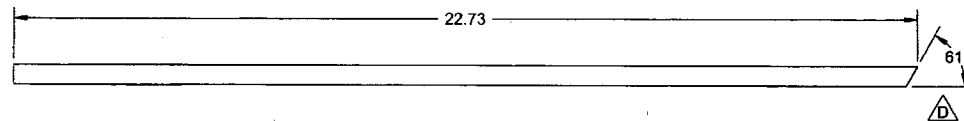
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NOTE: Date & initial all entries



86149

D4277-11 RIB



D4277-19 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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